

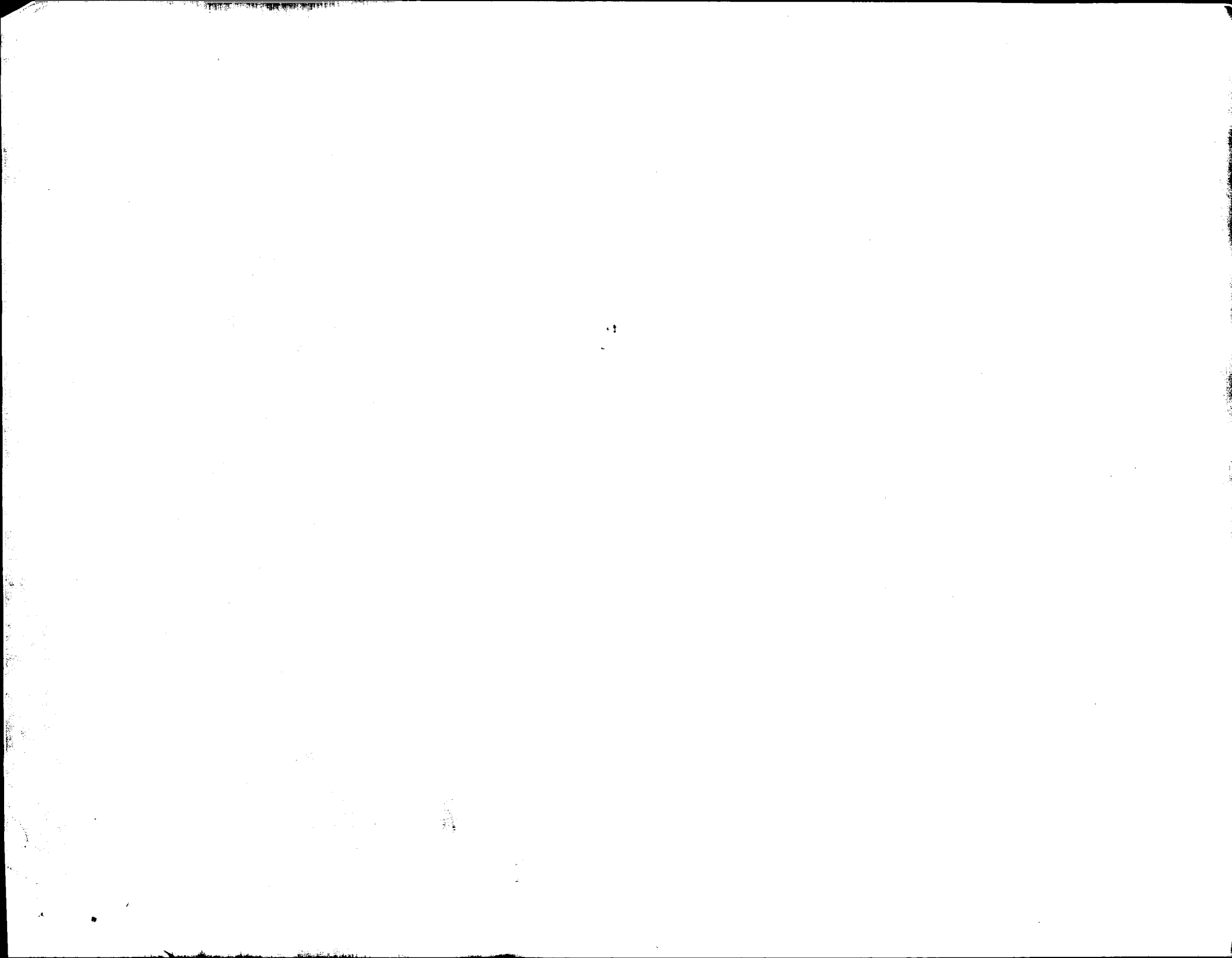
1-Weld end cap (ONE END-ONLY)
2-Grind end cap welds flush
3-weld lugs as per Dwg D4308

2 ϕ $\frac{Ac}{12.11.07}$

DAS
24
9-89 12.11.7

 Q_x

2 of 12
12.11.07



Work Order ID 92612

92612

Page 2

November-05-12 9:05:00 AM

Item ID: D4308-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step, RH Crew

Start Date: 11/05/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/12/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(2)	12-11-7		D4308-042 09-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(2)	12-11-7		D4308-042 09-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	NG 12-11-8		

Work Order ID 92612

92612

Page 3

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00				2	0		D43 23 09 PTO
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 122358 Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining end cap as per Dwg D4308 3-Grind end cap weld flush as per dwg D2841 4- install rivert as per dwg	0.00 0.00				2	0		12.11.08
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				2	12.11.9		D43 09 08

63

change step 160 To Qc 7 For blade inspection

D45
23
89

Work Order ID 92612

92612

Page 4

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190						2	12-11-9		DAS 09 2-23
QC	Memo	0.00							
Quality Control									
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200						2	NA	12-11-9	
HandFinish	Memo	0.00							
Hand Finishing									
205		0.00							
205						2			DAS 05 2-23
SprayPaint	Memo	0.00							12-11-12
Spray Painting	PRIME B 117319 DELFLEET BLUE B 123253 DELFLEET CLEAR B 118023								

05

05

Work Order ID 92612

92612

Page 5

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
212	QC14- Inspect Spray Paint	0.00							
212									
QC	Memo	0.00							
Quality Control									
215	Wing Walk as per dwg QSI005 4.4 Batch 122589	0.00							
215									
HandFinish	Memo	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									

DA 16 12/11/13

42
RTV

2 6 12/11-13

x2R11 d 12/11/13

Work Order ID 92612

92612

Page 6

November-05-12 9:05:00 AM

Item ID: D4308-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step, RH Crew
 Start Date: 11/05/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/12/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location	0.00							
230						2x			Sp
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

12/11/14

ME
12-11-13

Picklist Print

November-05-12 9:05:00 AM

Page 1

Work Order ID: 92612

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 11/05/12

Required Date: 11/12/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	165.2300	0.05	0.1		12.01.07	

Location Loc Qty Loc Code

HALL 16.37

46910 2

64409 6

66970 7.7

68293 0.25

72131 0.42

WA 139.5

81507 1.88

83894 12.38

88513 11.24

89750 114

WA013 9.36

75781 2

77612 7.36

D2734

Step End Plate

Manufactured No

120

Each

153.0000

1

2

12.11.07

Location Loc Qty Loc Code

WA 153

80682 6

84563 10

88714 32

91761 105

2

Picklist Print

November-05-12 9:05:00 AM

Page 2

Work Order ID: 92612

Parent Item: D4308-042

Parent Item Name: Step, RH Crew

Start Date: 11/05/12

Required Date: 11/12/12

Start Qty: 2.00

Required Qty: 2.00

D2734
Step End Plate

Manufactured No

170 Each 153.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	153	
80682	6	
84563	10	
88714	32	
91761	105	

2

D3458-1
Step Mounting Plate

Manufactured No

120 Each 16.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	13	
85693	13	
WA002	2	
75609	2	
WA018	1	
63075	1	

2

D3458-3
Step Mounting Plate

Manufactured No

120 Each 9.0000

1 2

12.11.07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	8	
82116	8	
WA002	1	
75610	1	

1

1

MS20601-AD4W2
Rivet

Purchased No

170 Each 64.0000

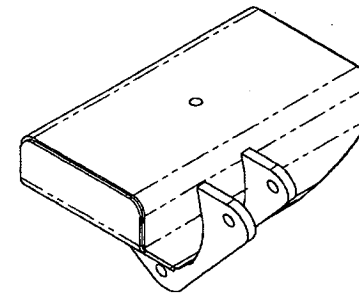
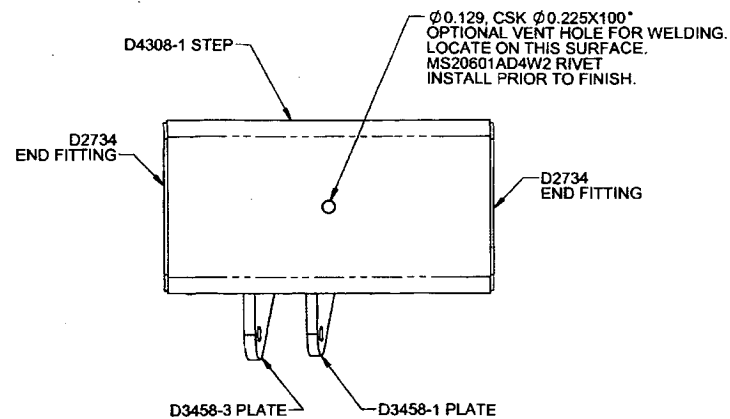
1 2

12.11.14

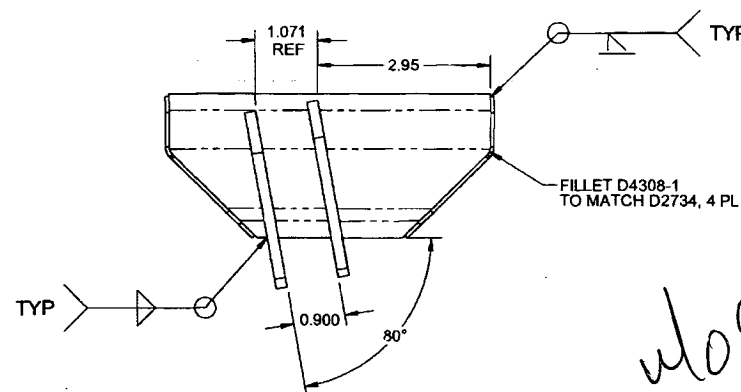
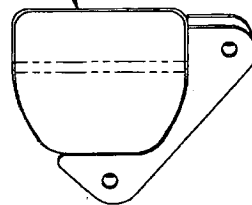
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	64	
122539	64	

64

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

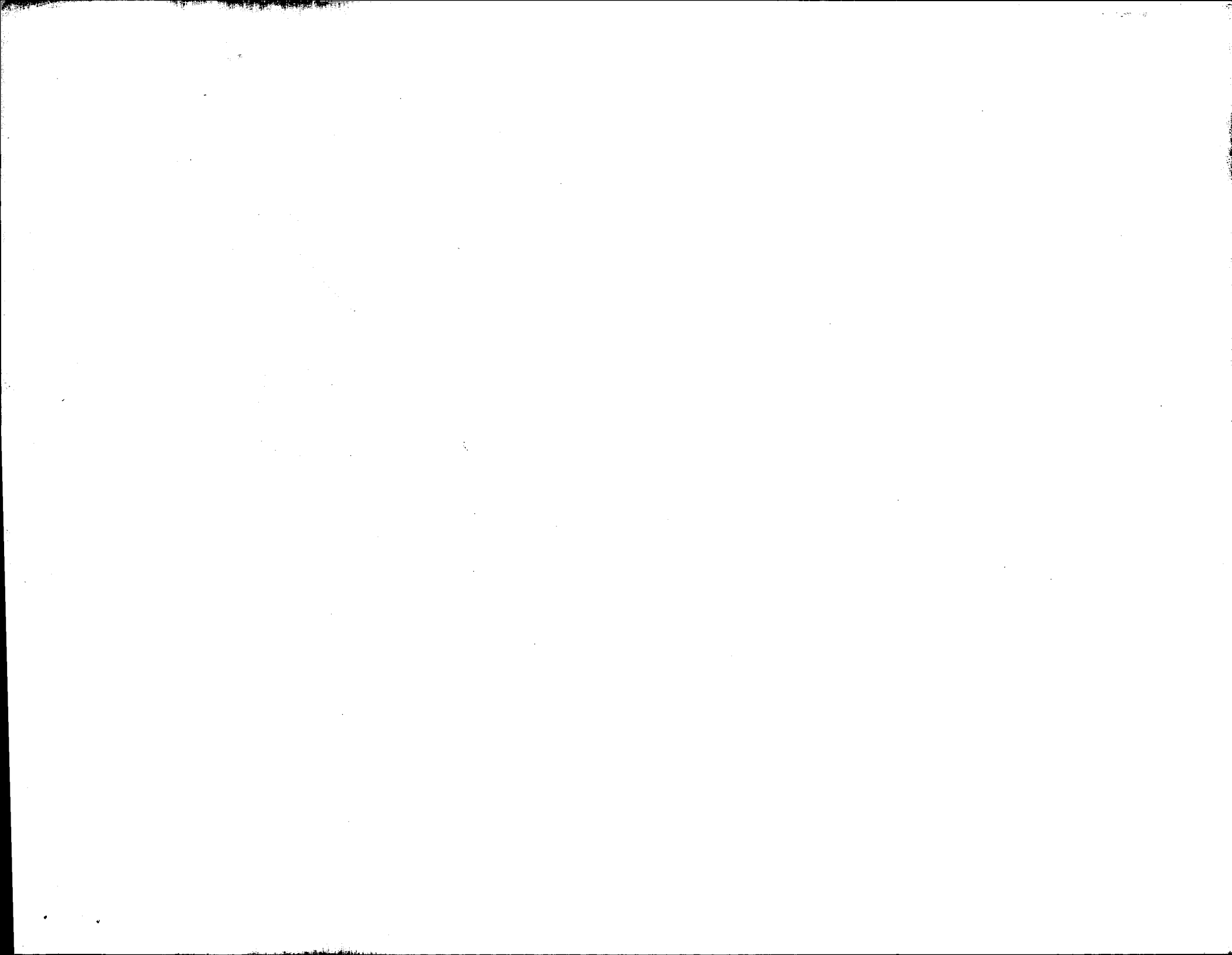
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

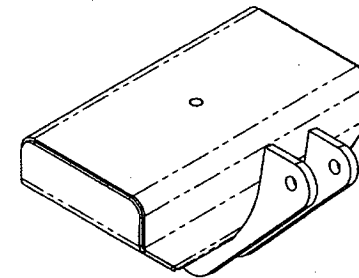
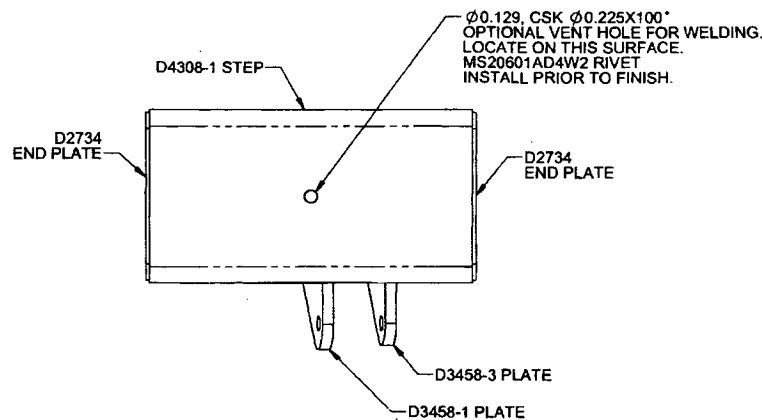
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DESIGN			BY	DATE
DRAWN		DART AEROSPACE LTD		
CHECKED		HAWKESBURY, ONTARIO, CANADA		
MFG. APPR.		DRAWING NO. D4308		REV. A
APPROVED		TITLE STEP, CREW		SHEET 1 OF 3
DE APPR.		SCALE NTS		
DATE	10.12.17	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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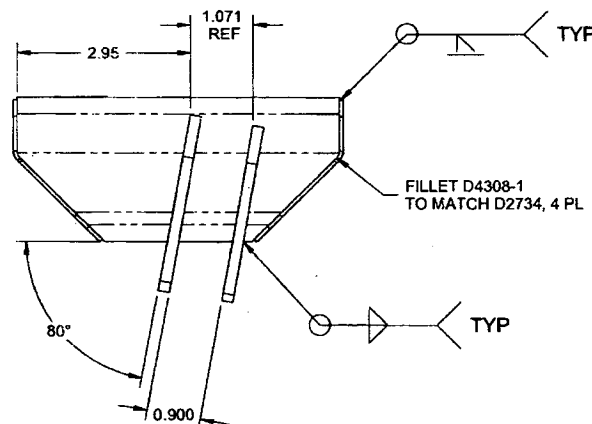
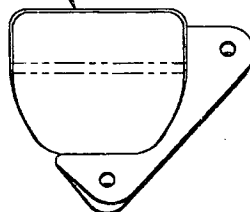
wlo92612



ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

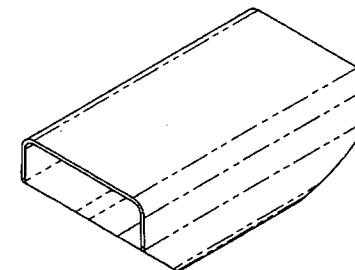
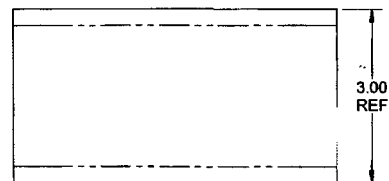
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
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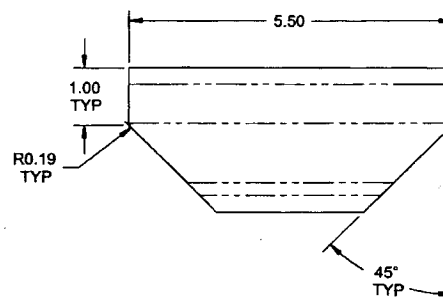
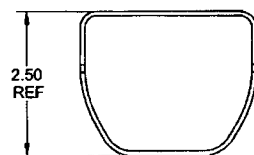
8 7 6 5 4 3 2 1

D



D

C



C

B

D4308-1 STEP

B

RELEASED
2011-05-20
MD

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

